

ABSTRACT OF THE DISCLOSURE

The invention relates to a welding method involving the use of a non-fusing electrode (12) according to which the electrode (12) is provided with power from a power source once the arc (11) between the electrode (12) and the workpieces (13, 14) to be joined has been ignited. The invention also relates to a tack welding method. The aim of the invention is to improve the quality of the weld seam in the starting phase of the welding process. To this end, the invention provides that before the actual welding process, a start program (22) is performed without the introduction of a filler material during which the electrode (12) is supplied with pulsed power in the form of current or voltage pulses over a presettable length of time (23) whereby causing the liquid molten bath to oscillate or vibrate, and that after the execution of the start program (22), the actual welding process is carried out during which the electrode (12) is preferably supplied with constant power.